

Work Order ID 165364

Monday, August 21, 2017 2:40:09 PM

Page 1

Item ID: 646.3719

Revision ID:

Item Name: Doubler

Start Date: 8/24/2017 Start Qty: 5.00

Required Date: 9/8/2017 Req'd Qty: 5.00

Reference:

Approvals:

Process Plan:

DAS

21

Date:

AUG 22 2017

Tooling:

Date:

QC:

9-89

Date:

SPC (Y/N):

Date:

Run

Start

NR1

Stop

NR2

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

646.3700

A

110

0.02

110

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg

Dwg Rev: AProg Rev: A

2-Deburr if necessary

0.13

120

0.00

120

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.05

646.3719
REV. A
B 165864

165364

Accept

N900040100

Setup

Start

NS1

Stop

NS2

Cust Item ID:

Customer:

⑤ 17/08/24 DAS
40
9-89⑤ 17/08/24 DAS
40
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Work Order ID 165364

Monday, August 21, 2017 2:40:09 PM

165364

Page 2

Item ID: 646.3719 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Doubler
Start Date: 8/24/2017 Start Qty: 5.00 ***5*** Cust Item ID:
Required Date: 9/8/2017 Req'd Qty: 5.00 ***5*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.10				<u>5</u>			DAS 38 9-89 AUG 25 2017
140 *140* Outsource4 Outsource process - Anodize	Outsource process-Anodize per QSI017 4.1.10.1 Memo Issue P/O to ATG : <u>37661</u> 1- Black Anodize as per Dwg 646.3700 2- PRIME AS PER DWG, SEE NOTE #2 Certification of Comformity is required	0.00 900.00				<u>5</u>			DAS 13 9-89 SEP 05 2017
150 *150* Packaging Packaging	Receive & Inspect for Damage & Mat'l Certs Memo	0.00 0.10				<u>5x</u>			SP17-9-25

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Work Order ID 165364

Monday, August 21, 2017 2:40:09 PM

165364

Page 3

Item ID: 646.3719 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Doubler
Start Date: 8/24/2017 Start Qty: 5.00 ***5*** Cust Item ID:
Required Date: 9/8/2017 Req'd Qty: 5.00 ***5*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160	QC5- Inspect part completeness to step on W/O	0.00							
-----	---	------	--	--	--	--	--	--	--

160

QC

Quality Control

Memo

0.10

1.8 mils thickness primer

SEP 27 2017

190

190

Packaging

Packaging

Identify as per dwg & Stock Location: *CCK105* 0.00

Memo

0.05

***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND
REV***DAS
6
9-89

SEP 27 2017

200

200

QC

Quality Control

QC21- Final Inspection - Work Order Release 0.00

Memo

0.50

17/9/27
um 17/9/27

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐		No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																			
Design ☐		Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																			
Doc/Data ☐		Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																			
Equip/Tooling ☐		Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																			
Handling/Pre ☐		Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																			
Material ☐		Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																			
Internal Transport ☐		Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																			
Tribal Knowledge ☐		Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																			
LOA ☐		Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																			
Substation ☐		Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																			
Past Expiry Date ☐		Manufacturing Process ☐	OTHER :																						
Misidentified ☐		Past Due ☐																							

Picklist Print

Monday, August 21, 2017 2:40:12 PM

Page 1

Work Order ID: 165364

165364

Parent Item: 646.3719

646 3719

Parent Item Name: Doubler

Start Date: 8/24/2017

Required Date: 9/8/2017

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A 12.10.22 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No			110	sf	152.9560	0.02778	0.146211			
									**			17/08/24	DAS 40 9-89
M6061T6S 063													
6061-T6 .063 Sheet													

Location

Loc Qty

Loc Code

MAT021

152.956

M134604

35.8

M134830

2.456

M136251

22.4

M136790

9.9

M137041

0.22

M137175

26.8

M137513

31.91

M137599

8.47

M138173

15

0,2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By 		
							Lead hand / Supervisor Approval Verification 		
							QC / QA Coordinator Approval 		

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : 			
Misidentified	☐	Past Due	☐				

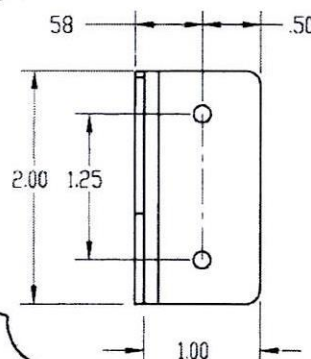
APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 03702				SHEET 1 OF 2	
	DWG NO. 646.3700	REV: A	PREPARED BY B. PETERS	DATE: 11/15/12	EFFECT ON DWG ☐ INC. ☒ UNINC.	
	DWG TITLE: SHEETMETAL					
APPROVED BY: ENGR <i>[Signature]</i>		MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF: NEXT ORDER		
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE	REASON: ADDED ALTERNATE MATERIAL AND REVISED REFERENCE DIMENSIONS				EOR: D-12-010	

SHEET 1, ZONE A2 IS:

IS

△ PRIMARY MATERIAL: ALUMINUM 6061-T6 PER AMS-QQ-A-250/11
ALTERNATE MATERIAL: SS 17-4 PH PER AMS 5604

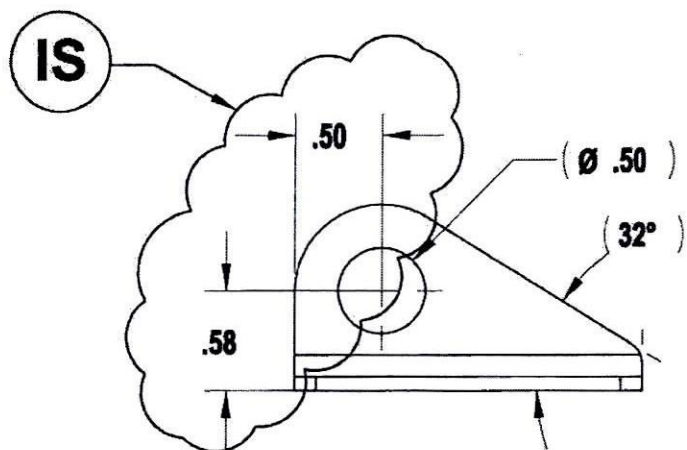
IS



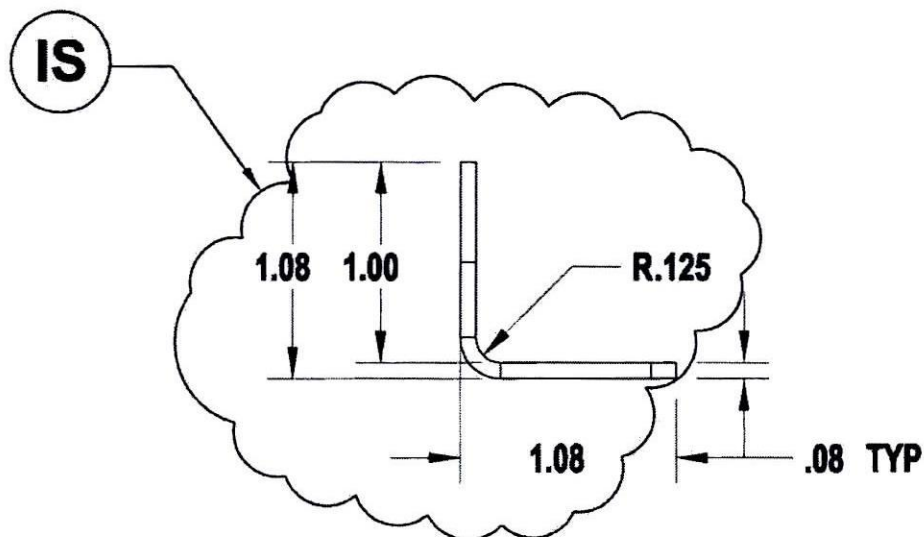
SHEET 7, ZONE B1 IS:

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 165364MCS
170822

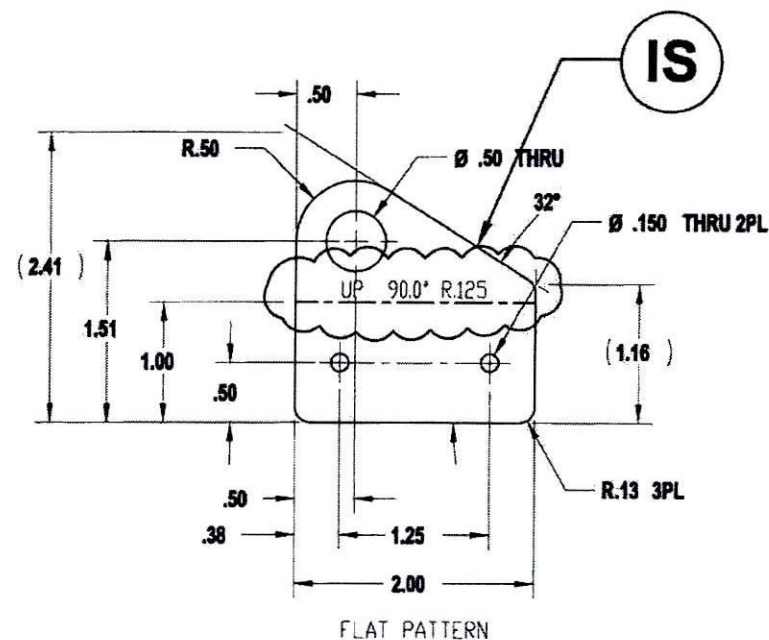
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED:				☐ RFMS ☐ MDL ☐ INSTALL INSTRUC ☐ ICA ☐ BOM	CHANGE CATEGORY ☐ MAJOR ☒ MINOR	DER REVIEW REQUIRED ☐ YES ☒ NO



SHEET 7, ZONE C4 IS:



SHEET 7, ZONE D1 IS:



SHEET 7, ZONE B7 IS:

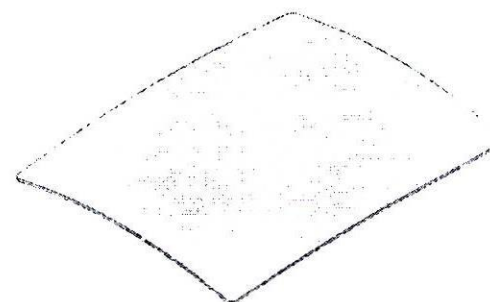
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION
-----	----	-------------	-----	-------------	------------------------

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REV.	DESCRIPTION	DATE	APPROVED
A	INCORPORATED ECN 02118	01/20/09	PE/20

NOTES:

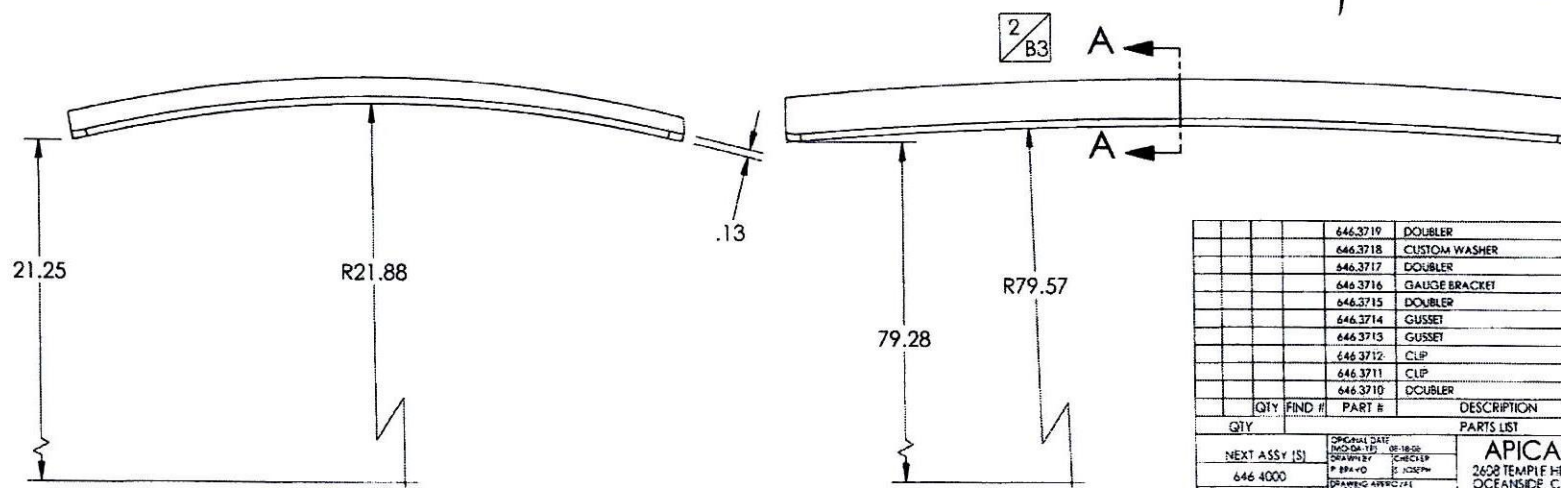
- 1 MATERIAL: ALUMINUM 6061-T6 PER AMS-QQ-A-250/11
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK;
CARDINAL 4840-50 PRETREATMENT PRIMER
PRIME IAW MIL-P-23377 J TYPE I CLASS N
- 3 MATERIAL: 17-4 PH AMS 5604, CONDITION H900
- 4 FINISH: PRIME IAW MIL-P-23377 J TYPE I CLASS N
5. DEBURR AND BREAK ALL SHARP EDGES
6. IDENTIFY IAW MPP-120



646.3710

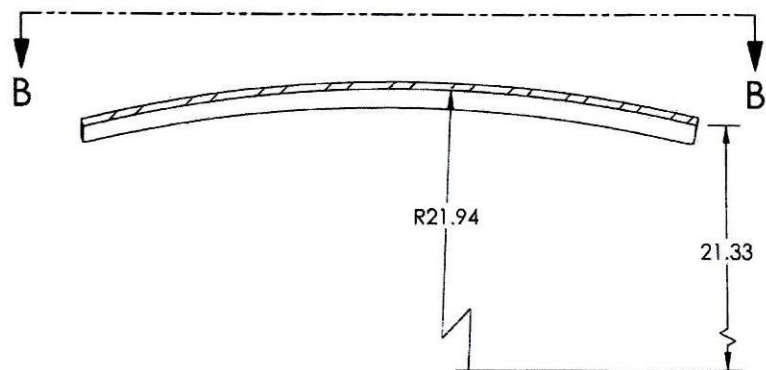
UNINCORPORATED ECN(s)

03702



QTY	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.
		646.3710	DOUBLER		
		646.3718	CUSTOM WASHER		
		646.3717	DOUBLER		
		646.3716	GAUGE BRACKET		
		646.3715	DOUBLER		
		646.3714	GUSSET		
		646.3713	GUSSET		
		646.3712	CLIP		
		646.3711	CLIP		
		646.3710	DOUBLER		
PARTS LIST			SHEETMETAL		
NEXT ASSY (S)			APICAL INDUSTRIES		
646 4000			2608 TEMPLE HEIGHTS DR.		
			OCEANSIDE, CA. 92056-3512 (760)724-5300		
			SHEETMETAL		
			646.3700		
			SCALE NONE		
			SHEET 1 OF 9		

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SECTION A-A



R.13 4PL

13.51

R395.138

10.49

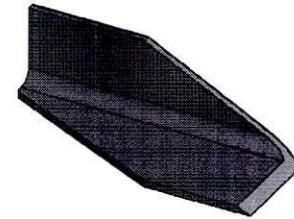
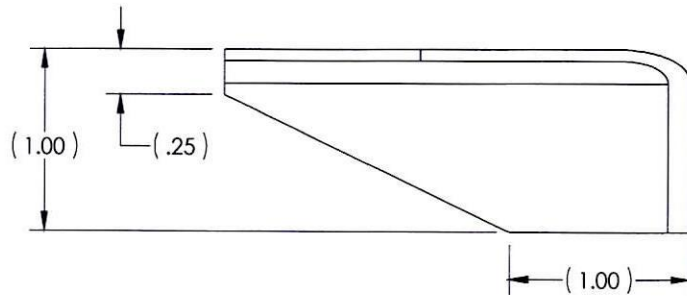
10.54

SECTION B-B

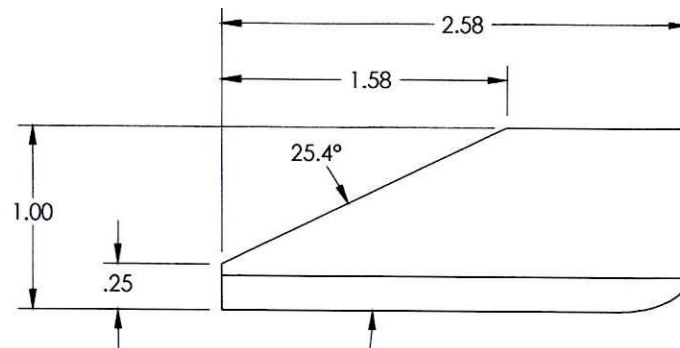
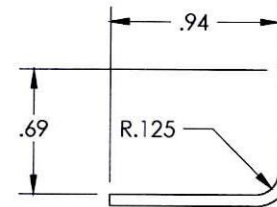
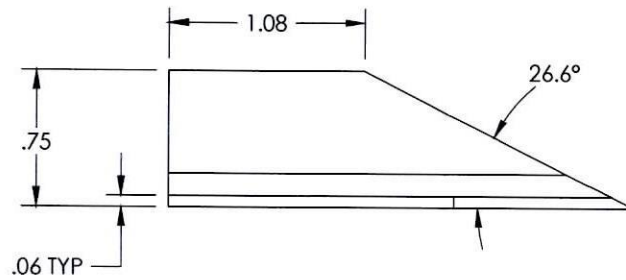
ORIGINAL DATE: 12/03/18		APICAL INDUSTRIES	
DRAWN BY: J. JOSEPH		2608 TEMPLE HEIGHTS DR.	
P. BRAY		OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL: J. JOSEPH		SHEETMETAL	
SOURCE: CUSTOMER		UNLESS OTHERWISE SPECIFIED	
		DIMENSIONS ARE IN INCHES	
		TOLERANCES ARE:	
		3 PLACE DECIMALS ±.01	
		AND .15 ±.01	
DR: B	CAGE CODE: 07M16	QTY: 646.3700	REV: A
SCALE: NONE		SHEET 2 OF 9	

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



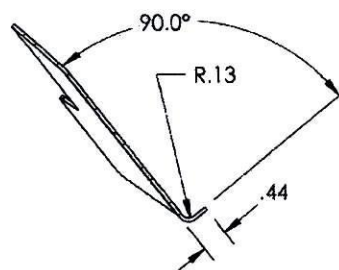
646.3711 SHOWN
646.3712 OPPOSITE



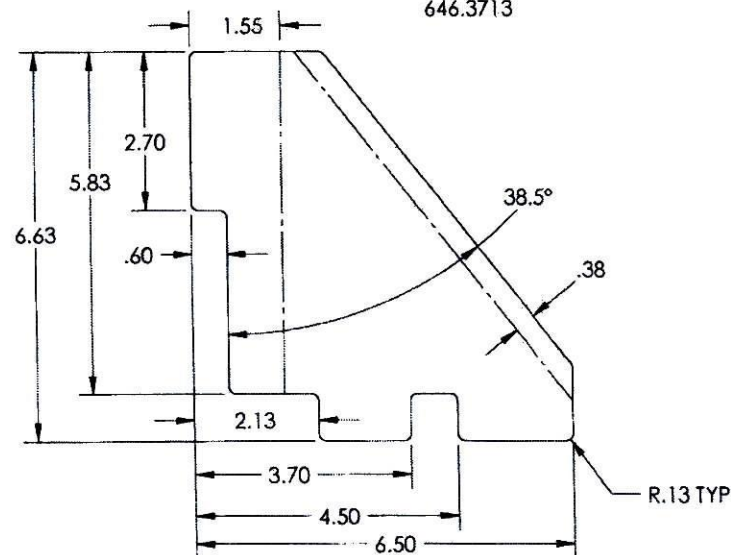
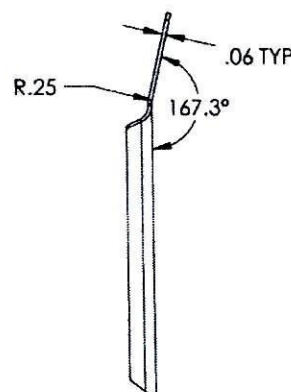
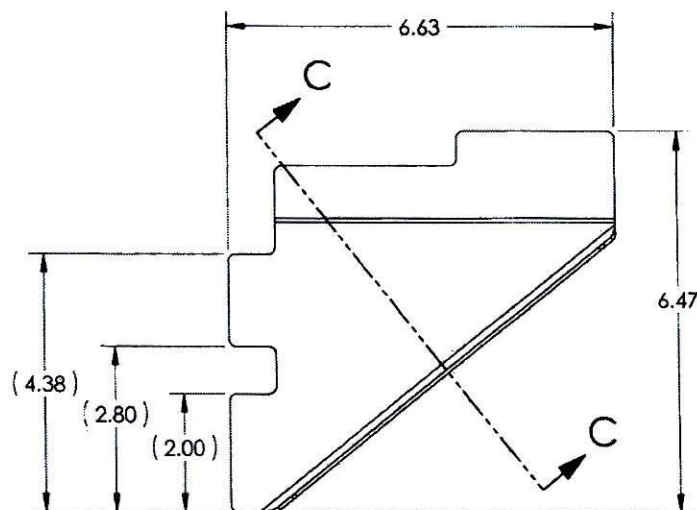
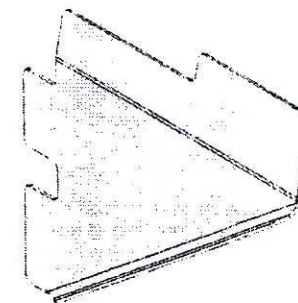
NEXT ASSY (S)	ORIGINAL DATE	08-18-08	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
	DRAWN BY	CHECKER		
	F. BRAVO	S. JOSEPH		
	DRAWING APPROVAL	S. JOSEPH		
	DATE	08-18-08	SHEETMETAL SCALE: NONE	
	CONTRACT NO.			
	UNLESS OTHERWISE SPECIFIED		SIZE	REV.
	DIMENSIONS ARE IN INCHES		8	A
	TOLERANCES ARE:		DWG. NO.	
	2 PLACE DECIMALS ±.01		646.3700	
	3 PLACE DECIMALS ±.005			
	ANGLES ±.3°			

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REVISIONS			
REV	DESCRIPTION	DATE	APPROVED



SECTION C-C

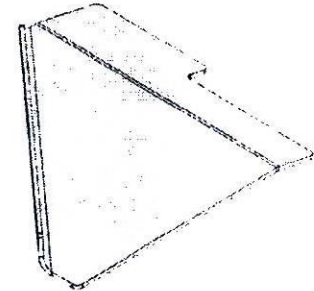
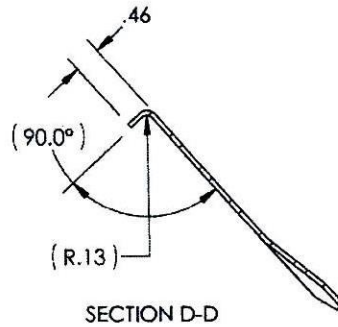
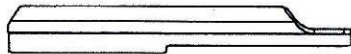


FLAT PATTERN

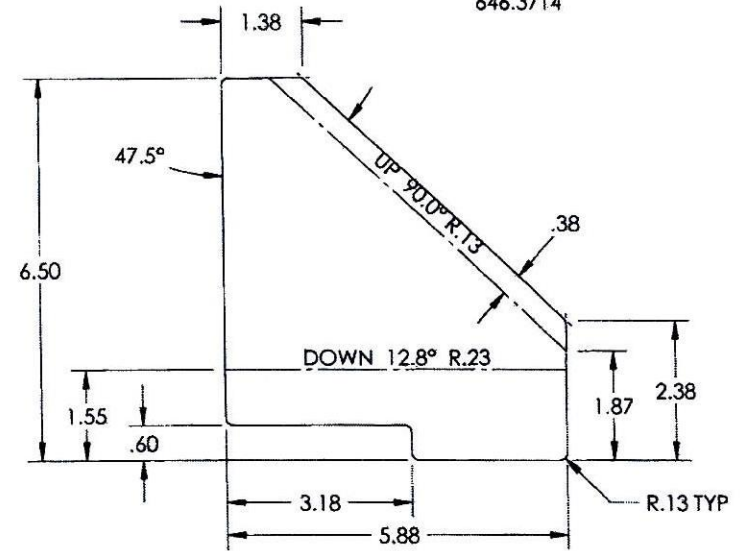
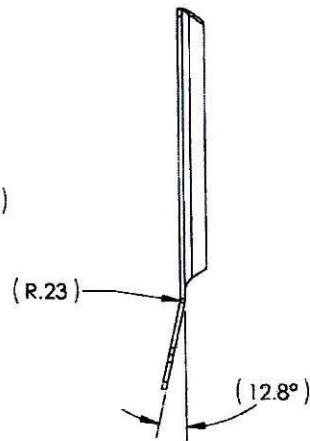
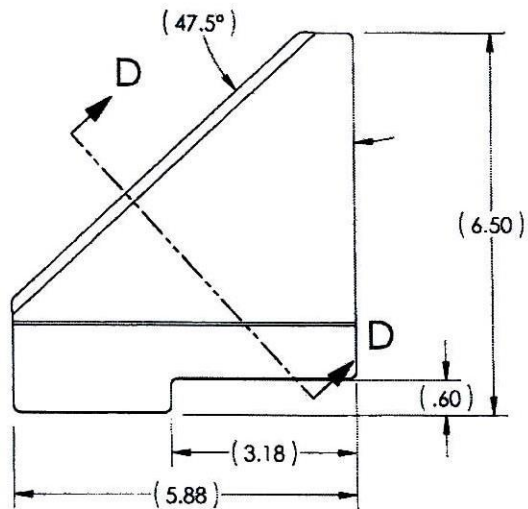
NEXT ASSY (S)	ORIGINAL DATE REV. 000000 DATE 01-10-80 BY M.V.O CHK'D J. JOSEPH	APICAL INDUSTRIES	REV. A
	PURCHASE REQUEST DATE 01-10-80 BY M.V.O CHK'D J. JOSEPH	2608 TEMPLE HEIGHTS DR OCEANSIDE, CA. 92056-3512 (760)724-5300	
	CONTACTING	SHEETMETAL	
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONS DECIMALS INCHES 1/16 1/32 1/64 .005 .010 .015	646.3700	
		SCALE: 1/8"=1"	SHEET 1 OF 1

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REV	DESCRIPTION	DATE	APPROVED



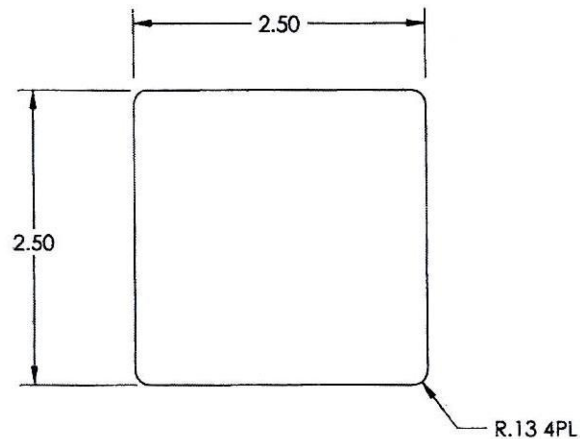
646.3714



ORIGINAL DATE: 08-18-08 DRAWN BY: J. JOSEPH CHECKED BY: J. JOSEPH DESIGNED BY: J. JOSEPH PART NO.: 646.3714 CONTRACT NO.:		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: .3" & OVER ±.01 .1" & OVER ±.005 ANGLES ±.5°		SHEETMETAL 646.3700	SHEET 5 OF 9

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THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED

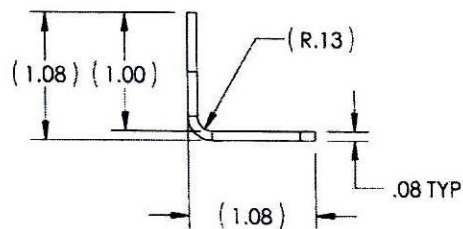
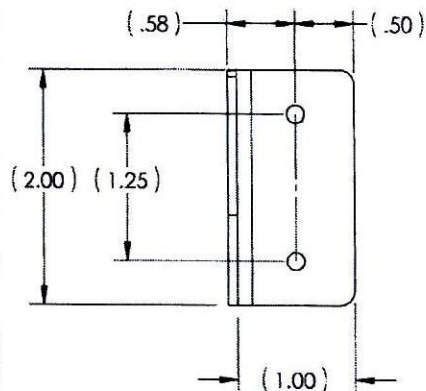


646.3715

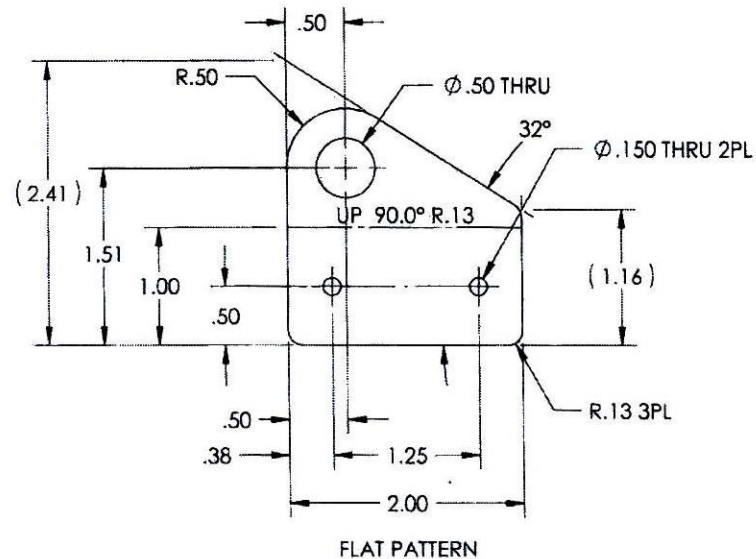
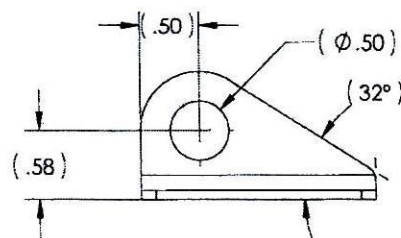
NEXT ASSY (S)		ORIGINAL DATE 08-18-08	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
DRAWN BY P. BRAYO		DESIGNED BY E. JOSEPH		
CHECKED BY S. JOSEPH		APPROVED BY S. JOSEPH		
CONTRACT NO.				
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°			SHEET CODE B DWG. NO. 07M26 SCALE 1/8"=1"	REV A 646.3700 SHEET 4 OF 9

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REV	DESCRIPTION	DATE	APPROVED



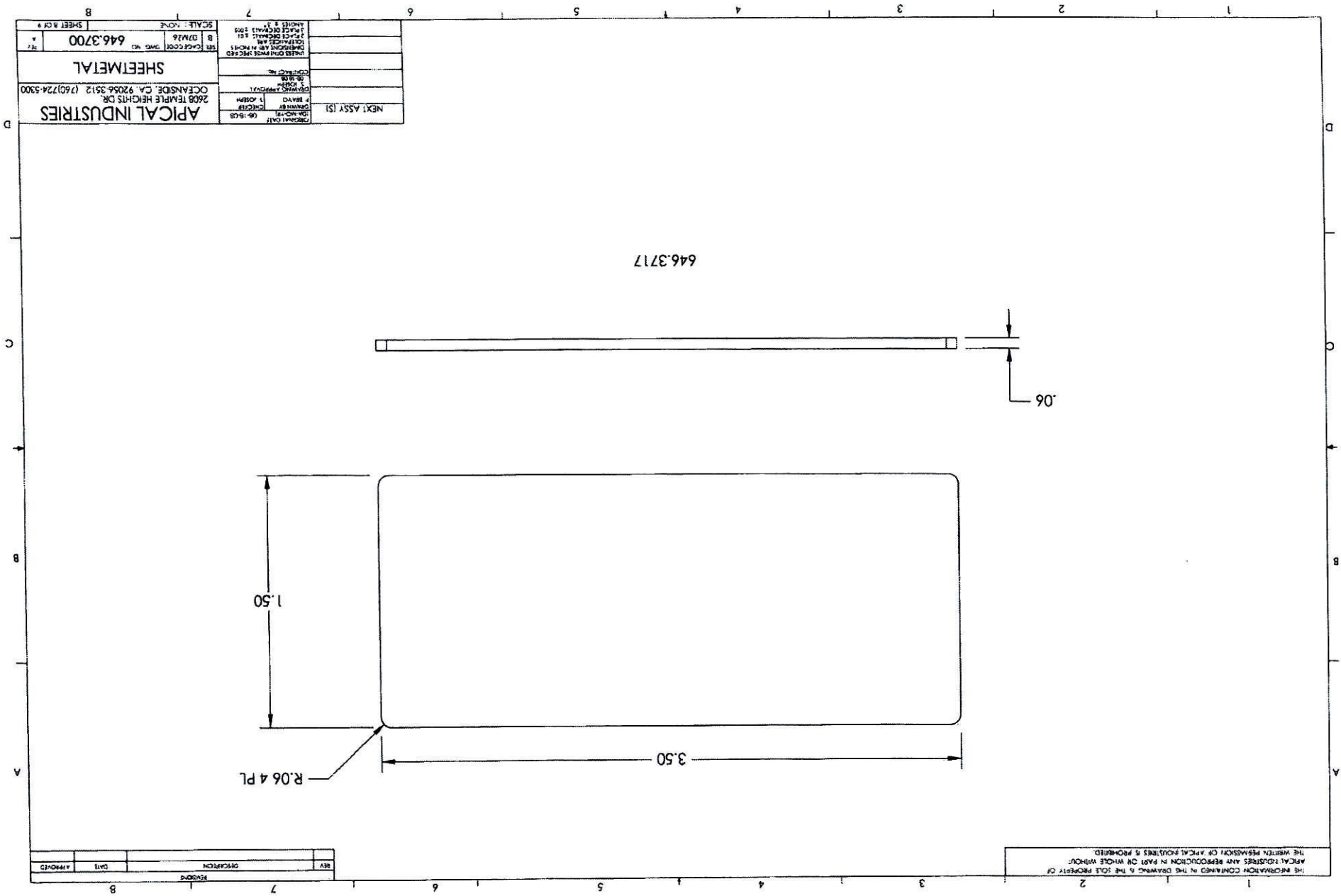
646.3716



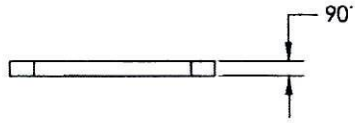
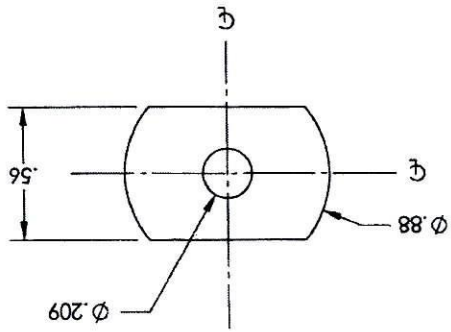
FLAT PATTERN

NEXT ASSY IS)	ORIGINAL DATE 08-18-06	APICAL INDUSTRIES
	DRAWN BY J. KOSBY	2608 TEMPLE HEIGHTS DR.
	CHECKED J. KOSBY	OCEANSIDE, CA 92056-3512 (760)724-5300
	DESIGNED BY J. KOSBY	
	DATE 08-18-06	
	CONTRACT NO.	
	UNLESS OTHERWISE SPECIFIED	
	ENGINEERING AND FINISHES	
	TOLERANCES ARE	
	2 PLACE DECIMALS ± .01	
	3 PLACE DECIMALS ± .005	
	ANGLES ± .5°	
	SCALE: 1"=1"	

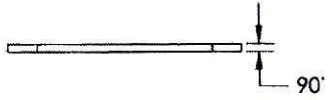
APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA 92056-3512 (760)724-5300
SHEETMETAL
646.3700
SHEET 7 OF 4



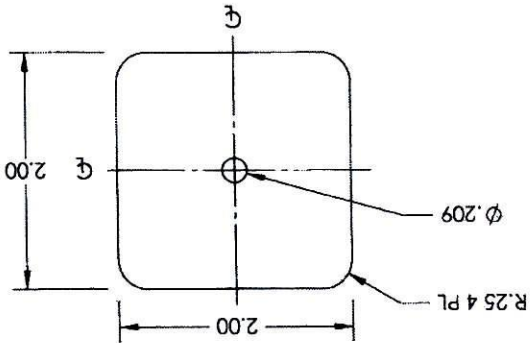
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APICAL INDUSTRIES. ANY REPRODUCTION IN PART OR WHOLE WITHOUT
THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.



646.3718



646.3719



APICAL INDUSTRIES		SHEET 001	
2608 TEMPLE HEIGHTS DR		646.3700	
OCEANSIDE, CA 92056-3512 (760) 724-5300		REV. A	
NEXT ASSY (S)		SCALE: 1"=1"	
DESIGNED BY: J. JOHNSON		DATE: 07/26/86	
CHECKED BY: J. JOHNSON		DWG. NO. 646.3700	
APPROVED BY: J. JOHNSON		SHEET 001	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO37661

Purchase Order Date 9/5/2017
PO Print Date 9/7/2017

Page Number 2 of 5

Order From :

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

VC-ATG001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613-446-4544

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

VENDOR'S TRUCK

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Diane Baker

10127-2607

Net 30

CAD

FCA - (Free Carrier)

3 165190

647.0310 Channel

9/12/2017

Yes

9/12/2017

16.00

\$11.10

\$177.60

Hard Anodize Color Black, Per IAW MIL-A-8625 Type III Class 2 as per MPP-172 Section 4.2
Prime as Per IAW MIL-P-23377 J Type I Class N
B165190

SPA 9-27.

4 165122

646.9810 Deflector

9/12/2017

Yes

9/12/2017

26.00

\$47.25

\$1,228.50

Hard anodize IAW MIL-A-8625 Type III Class 2, Color Black
Prime IAW MIL-P-23377J Type I Class N, 1-2 MIL Max
B165122

Rec'd 4

rec'd 22x SPA 9-27.
SPA 9-15.

Line Total:

\$177.60

5 165364

646.3719 Doubler

9/12/2017

Yes

9/12/2017

5.00

\$6.15

\$30.75

Hard Anodize IAW MIL-A-8625 Type III Class 2, Color Black
Prime IAW MIL-P-23377J Type I Class N
B165364

SPA 9-27

Line Total:

\$1,228.50

PO Instructions: PRIMER IS SUPPLIED BY DART

Note:

9/7/2017

DA
38
9-89



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 913909

Date: 26-Sep-17

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577 Fax: 613 632-1555	
Terms	
Ship Via	
OUR TRUCK	
Quantity	Description
Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.	
3 ea	Part: RBEM632V3013101-7 Cover Clear Anodize per MIL-A-8625F, Type I, Class 1, .0004-.0010" (.4 - 1 mils). Job: 21674
	Rev: 1 PO: PO37661 Line: 10
16 ea	Part: 647.0310 Channel Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils). Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils). Job: 21667
	Rev: PO: PO37661 Line: 3
5 ea	Part: 646.3719 Doubler Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils). Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils). Job: 21669
	Rev: PO: PO37661 Line: 5
5 ea	Part: 647.4114 Shim Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils). Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils). Job: 21671
	Rev: PO: PO37661 Line: 7
5 ea	Part: 647.4115 Shim Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils). Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils). Job: 21672
	Rev: PO: PO37661 Line: 8
Made in Canada.	

Made in Canada.



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 913909

Date: 26-Sep-17

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>26/9/17</u> Certified Signature: <u>[Signature]</u> Receiver Signature: <u>SP17-9-27</u> A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.		
Made in Canada.			

DA6
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9-80